Tuesday, 10/24/2006 11:03:33 AM

User:

**Process Sheet** 

Customer : CU-DARÕ01 Dart Helicopters Services

Job Number : 29137 **Estimate Number** : 11859

P.O. Number This Issue

: 10/24/2006 : NA

: 26459

S.O. No. : NIA

: SMALL /MED FAB Type

Part Number **Drawing Number** 

**Drawing Name** 

: D2374 : D2374 REV A

: STUD

Project Number : N/A **Drawing Revision** Material

**Due Date** : 10/31/2006

Qty:

Each

**Previous Run** Written By

Prsht Rev.

First Issue

Checked & Approved By

Comment

: Est.

Reformat; Made on Cobra KJ/RF

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

MDELRINR1000



Delrin Round Bar 1"



Comment: Qty.: Total: 5.3382 f(s) 0.1335 f(s)/Unit

Delrin Round Bar 1"

Material: Black Acetal (Delrin) 1.00" Ø Rod (M-DELRIN-R1.000)

Batch: M 101078

2.0



HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Turn blank as per Folio FA156 and Dwg D2374

Deburr as required

3.0 QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

5.0

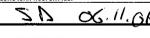
SECOND CHECK



Comment: SECOND CHECK

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA156 and Dwg D2374

W/O:		WORK ORDER CHANGES									
DATE	STEP	es	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		*									
Part No	:		PAR #:	Fault Category:	NCR:	Yes	No DQ	A: 2	<u>)</u> Date:	8/11/0	
							N/C Close				

NCR:			WORK ORDE	R NON-CONFORMANC	E (NCR)					
	STEP	Description of NC		Verification						
DATE		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
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		·		. 8		1				
				â:						
-0										

NOTE: Date & initial all entries

Tuesday, 10/24/2006 11:03:33 AM Date: Kim Johnston User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: STUD** Job Number: 29137 Part Number: D2374 Job Number: Seq. #: Description: **Machine Or Operation:** INSPECT PARTS AS THEY COME OFF MACHINE 6.0 QC2 48 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 7.0 SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr as required SECOND CHECK 8.0 QC8 Comment: SECOND CHECK PACKAGING 1 9.0 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 10.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

## **Dart Aerospace Ltd**

· oopaoo .												
	49	WORK ORDER CHANGES										
STEP	PRO	OCEDURE CHAI	NGE	Ву	By Date Qty			Approval QC Inspector				
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			, ÷				•					
:	PAR #:	Fault Cate	jory:	NCR: Yes	No <b>DQ</b>	A:	Date: _					
				QA:	N/C Close	d:	Date:					
		WORK ORDE	ER NON-CONFORM	ANCE (NC	R)							
CTED	Description of NC	Corrective Action Section B			Verifi	cation	Approval	Approval				
SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		& Sect		Chief Eng	QC Inspector				
							0					
	•											
			*									
	STEP	STEP PAR #:  PAR #:  STEP Description of NC Section A	STEP PROCEDURE CHAIN  PAR #: Fault Cates  WORK ORDE  STEP Description of NC Section A Initial Chief Eng	WORK ORDER CHANCE  PROCEDURE CHANGE  Fault Category:  WORK ORDER NON-CONFORM  STEP  Description of NC Section A  Corrective Action Section Description Chief Eng  Action Description Chief Eng	STEP PAR #: Fault Category: NCR: Yes  QA:	STEP PROCEDURE CHANGE By Date  PAR #: Fault Category: NCR: Yes No DQ QA: N/C Close  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Children (Children Children Chil				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29137
Description: Stud	Part Number:	D2374
Inspection Dwg: D2374 Rev: A		Page 1 of 1

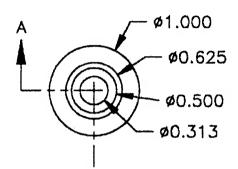
FIRST ARTICLE INSPECTION CHECKLIST							
		X First Ar			totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	nments
1.000	+/-0.010	. 999					
0.625	+/-0.010	.6235					
Ø0.500	+0.005/-0.000	.503					
Ø0.313	+0.005/-0.000	.312	-				
R0.062	+/-0.010	,062					
0.300	+/-0.010	. 295	/				
1.313	+/-0.010	1.311	/				
0.125	+/-0.010	, /30"	V/				
0.772	+/-0.010	779"					
R0.563	+/-0.010	RO 563"					
Measured by: Date:	M2 06/11/3	Audited by:		111/03	Prototype Ap	oproval:	N/A N/A

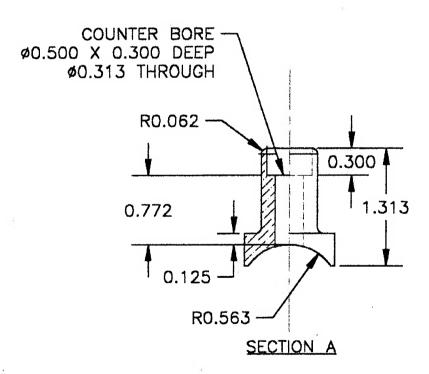
Rev	Date	Change	Revised by	Approv∉d
Α	05.04.25	New Issue	KJ/JLM	
			7 ()	





DESIGN B WILLIAMS	drawn by K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV.	. A
BW	4	D2374 SHEET	1 06	۶ 1
DATE	•	TITLE	SCA	Œ
95:02:24		STUD		1:1





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